

Date: Wednesday, 02/04/2008 11:27:06 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 6" MIRROR		
Job Number	: 38288			Part Number	: D2011101		
Estimate Number	: 10101			Drawing Number	: D2011 REV. F		
P.O. Number	:			Project Number	: N/A		
This Issue	02/04/2008	S.O. No.	:	Drawing Revision	: F		
Prsht Rev.	: NC			Material	:		
First Issue	11	Type	SMALL /MED FAB	Due Date	11/04/2008	Qty:	50
Previous Run	: 37326			Um:	Each		
Written By	:			Comment	:		
Checked & Approved By	: JD 08.04.02			Est: J 04.09.15	Added Steps 5-7 KJ/JLM		
Comment	:			Est: K 05.12.15	chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING <i>C 208/04/02 (50)</i>
2.0	28043	MIRROR 6" <i>6054 (50)</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>1/9/03 (50)</i>
4.0	QC6	DIMENSIONAL CHECK <i>503/04/03 (50)</i>
5.0	D30141	Locknut <i>503/04/03 (50)</i>

Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

Comment: DIMENSIONAL CHECK

Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Locknut
 Pick:
 Qty Part Number Description Batch
 1 D3014-1 Lock nut B18605 ✓ *ml 08/04/07*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 38288

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN960JD416L	Washer	<u>M107008</u>



ml08/04/07

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241adhesive per hole.

Qty	Part Number	Description	Batch
9ml	N/A	Sikaflex-291-241	<u>M105585</u>
		Expiry date	<u>10/2008</u>

Start: 08/04/07 Time: 10:30 AM

Finish: Time: 10:30 AM

ml08/04/07

8.0 QC5

8/4/9

8:00 AM

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

8/04/09 X5

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 027

8/4/9

SP

50X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W

08-04-09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

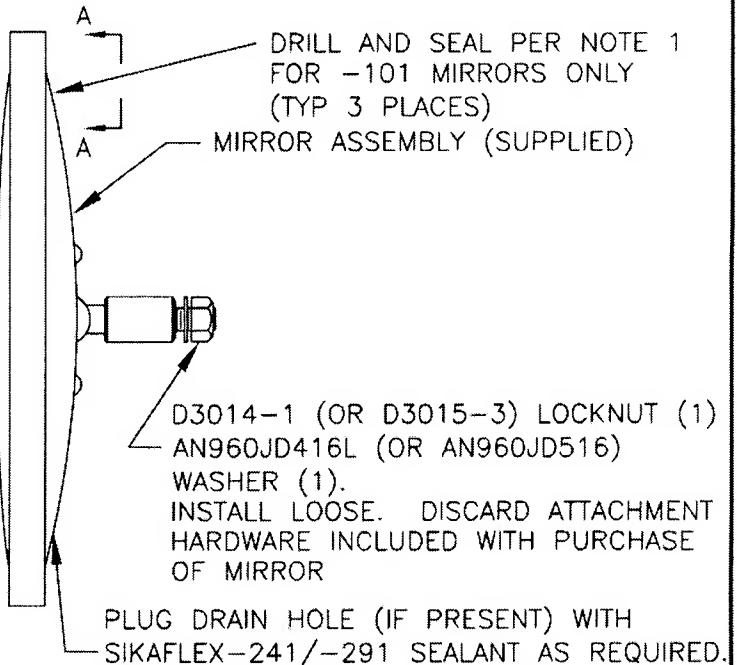
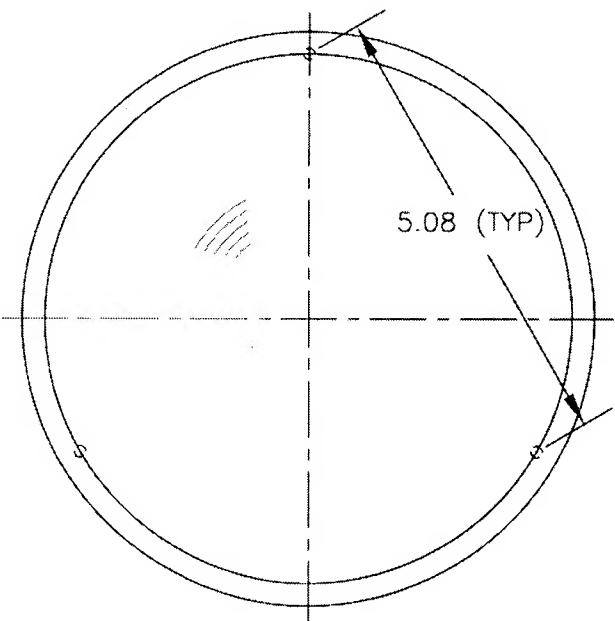
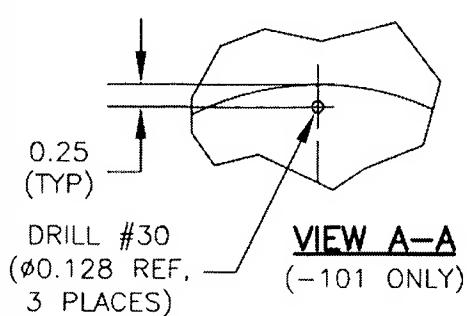
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2011	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.10		MIRROR ASSEMBLY	1:2



RELEASED
R 6/10/90

QTY -101	QTY -103	Part Number	Description
X	X	D2011-101	MIRROR ASSEMBLY 6"
		D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) $\varnothing 0.128$ HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38288

Benson
+1953

**AUTO PARTS • PIÈCES D'AUTO
TRUCK PARTS • PIÈCES DE CAMION
ENGINE-MARINE • MOTEUR-MARINE
PERFORMANCE PARTS • PIÈCES DE PERFORMANCE
TIRES • PNEUS**

Benson
+1953

Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.

TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours. 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeureront la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournable.

TERMES: Compte payable le 10 du mois suivant.

SIGNATURE

GST / TPS
10035 3366 RT0001

1000 RUE LANDSDOWNE HAWKESBURY, ON K6A 1H7
TEL: (613)632-1191 FAX: (613)632-2350

TVQ
1016330716 TO0001

Pour chaque tranche d'achat de \$200 de produits Walter entre le 15 mars et le 15 avril>>> une chance de gagner une TV a écran plat 32". Contactez votre Rep.

113336	(613)632-5200	E S P S H I P E R I T O R A	113336 *** SAME ***	DATE: 4/03/08 03:56 111 MLP
S Y O E D A R T A E R O S P A C E L T D U T O A H A W K E S B U R Y	EDART AEROSPACE LTD. 11270 ABERDEEN STREET ON K6A 1K7			PO: 0000-6054
ORD / COM	SHIP / EXP CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN
50	HC-088	28043 direct grote SHIP VIA	6" CONVEX ASSEMBLY PIECES/CORE TOT REGULAR	43.09 0.00
				15.60
INVOICE No / FACTURE	TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS
113365134	INVOICE	780.00	0.00	0.00
			GST / TPS	PST / TVQ
			39.00	0.00
			AMT to PAY / À PAYER	
			819.00	